

Date: Wednesday, 3/12/2008 1:42:06 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	LUG BRACKET		
Job Number	37860			Part Number	D27351		
Estimate Number	10009			Drawing Number	D2735 REV C		
P.O. Number				Project Number	N/A		
This Issue	3/12/2008	S.O. No.		Drawing Revision	C		
Prsht Rev.	NC	Type	SMALL /MED FAB	Material			
First Issue	/ /			Due Date	3/24/2008	Qty:	40
Previous Run	37437			Um:	Each		
Written By	<u>HF 08 03 18</u>						
Checked & Approved By							
Comment	Est Rev:C	Removed from 9 Digit	05-10-25	JLM			
	est rev D	waterjet	06.09.19	EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125
		Comment: Qty.: 0.1733 sf(s)/Unit Total : 6.9300 sf(s) 1010-1025 sheet .125 batch: <u>166140</u> <u>HR 8-3-18</u>
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D2735 (D2735-1) Dwg Rev: <u>C</u> <u>HR 8-3-18</u> Prog Rev: <u>C</u>
		2-Deburr if necessary <u>HR 8-3-18</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<u>HR 8-3-18</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		<u>HR 8-3-18</u>
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		<u>HR 8-3-18</u>
		Comment: NC BRAKE 1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204 SPB 08/04/01
		2-Deburr if required.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 37860

Part Number: D27351

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



08/04/02 (40)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST244 (Temporary)

AS 08/04/03 (40)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/04 (40)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37860
Description: Lug Bracket	Part Number:	D2735-1
Inspection Dwg: D2735 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	BB	Audited by:		Prototype Approval:	N/A
Date:	8-3-18	Date:	08/03/18	Date:	N/A

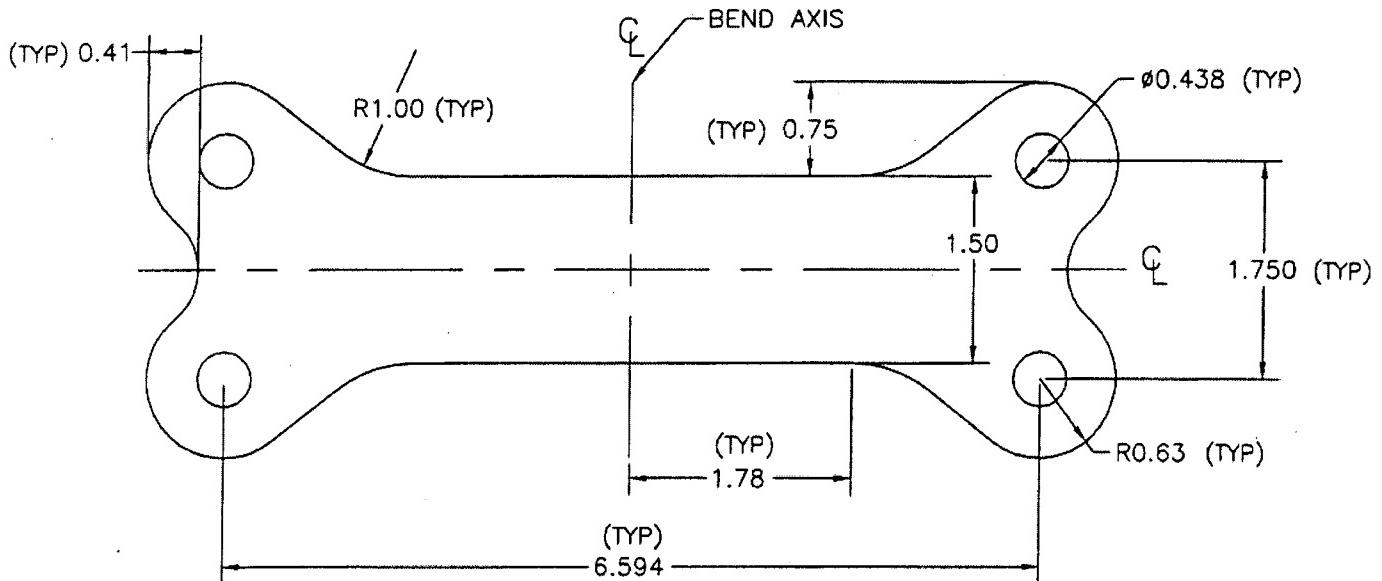
Rev	Date	Change	Revised by	Approved
A	07.02.02	New Issue	KJ/JLM	<i>[Signature]</i>

DART

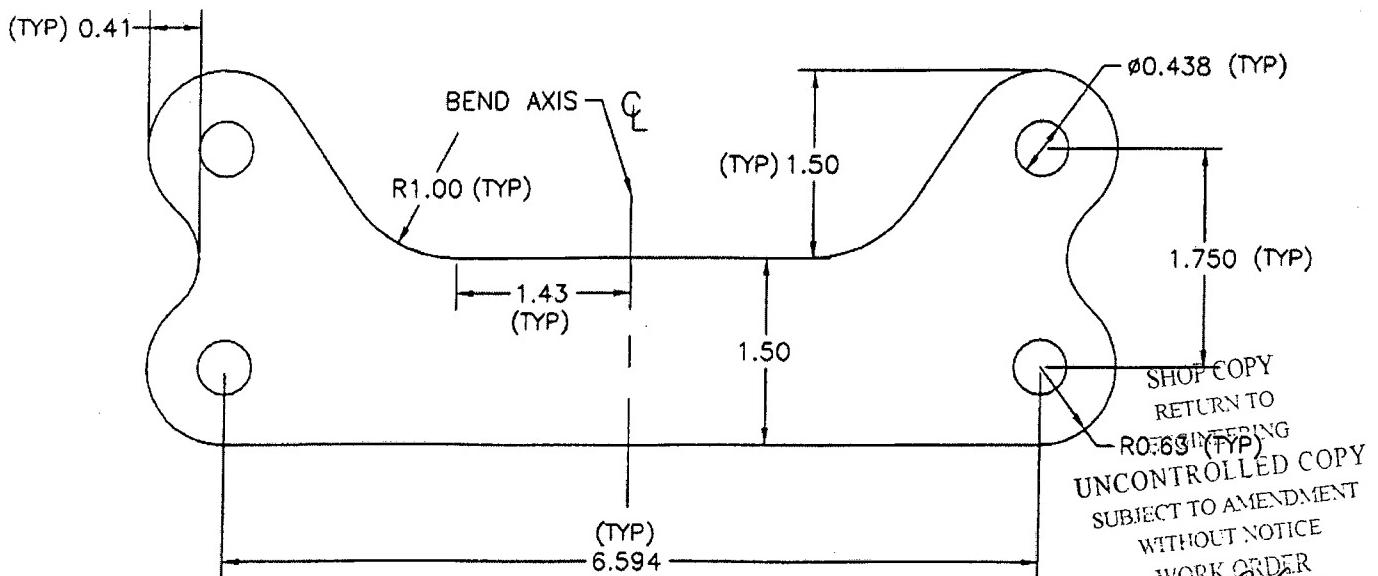


DESIGNER <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO.	REV. C
DATE 98.12.14		TITLE LUG BRACKET	SHEET 1 OF 2
			SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS



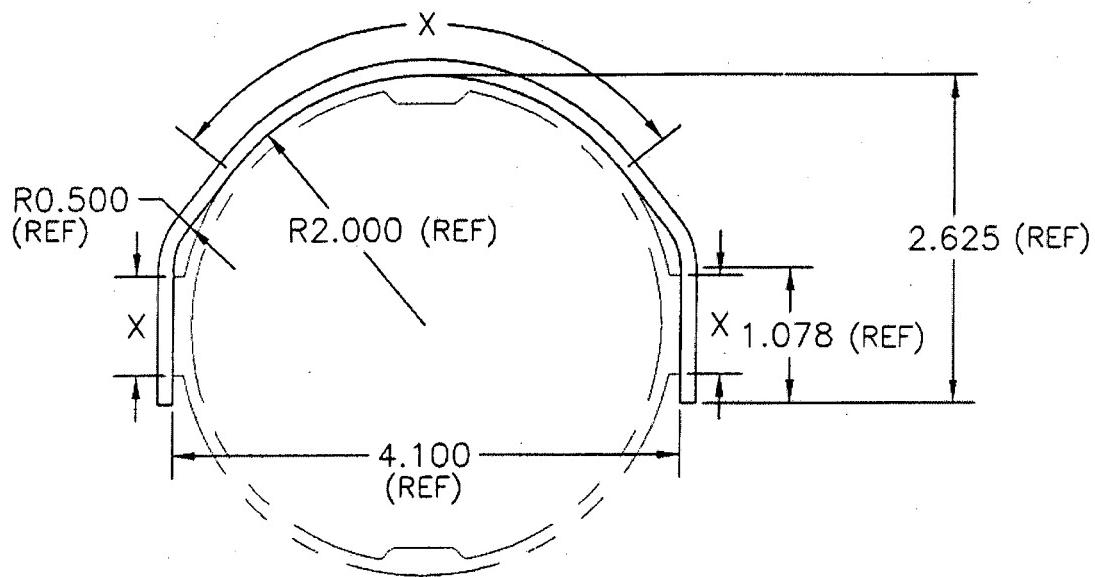
D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)



D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (C)

DART

DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735
DATE 98.12.14		TITLE LUG BRACKET

REV. C
SHEET 2 OF 2
SCALE
2:3**RELEASED**
98.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES
MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37860

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES